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PATENT ABSTRACTS OF JAPAN(21) Application number: **53106417**(51) Intl. Cl.: **B21F 19/00**(22) Application date: **31.08.78**

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publication: **10.03.80**(84) Designated contracting
states:(71) Applicant: **TOSHIBA CORP**(72) Inventor: **ISHIZAKI HIDEO**

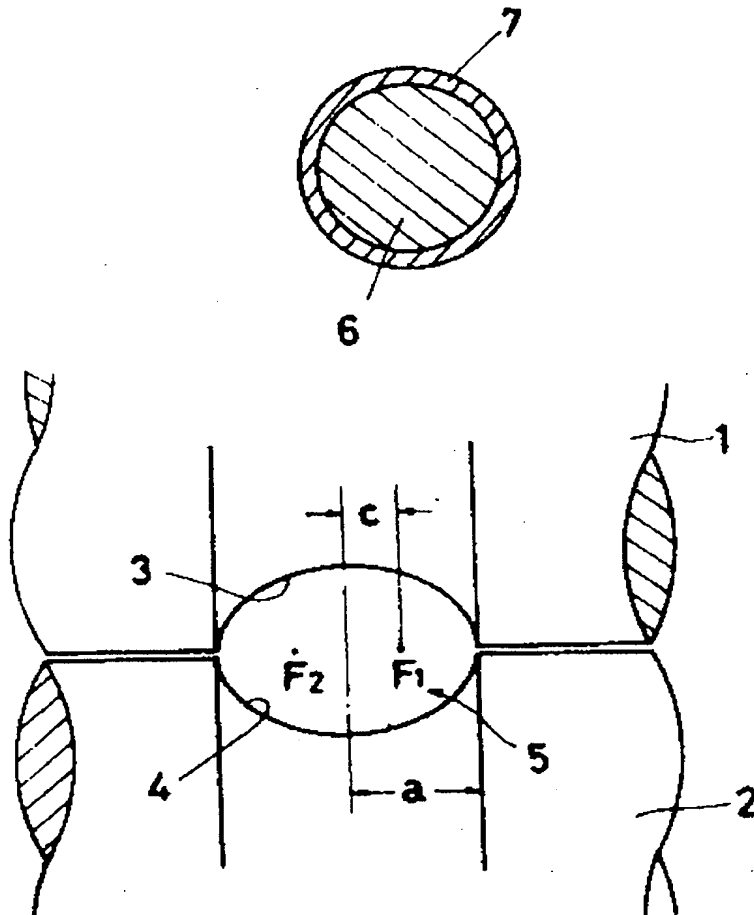
(74) Representative:

**(54) PRODUCTION OF
COMPOSITE WIRE**

(57) Abstract:

PURPOSE: To eliminate the uneven wall thickness of covering material and obtain the composite wire of high quality by covering a copper covering material on an iron-Ni alloy core wire and rolling this within a range of width spreading rate 0.25 or over and up to 0.45 with a pair of rolls forming the specific oval hole.

CONSTITUTION: The hole dies 5 formed by the die grooves 3, 4 of a pair of rolls 1, 2 are formed to an oval shape of eccentricity 0.28 to 0.33 range (actually multiple hole dies of respectively varying sizes are prepared). The blank comprising covering a cylindrical copper converging material 7 on a round bar core material 6 composed of iron-Ni alloy is passed through the first die hole 5, thence it is once forced to a circular shape by the circular hole die rollers. After the axial center is turned 90°, the blank is passed in the next hole dies 5. Thereafter, this is repeated 10 times. In rolling, the ratio of the spreading margin of the width orthogonal to the crushing direction of the blank is so set as to become 0.25 or more and up to 0.45. As a result, the flow of the material at the rolling is evened and the deviation of the thickness of the covering material 7 is eliminated.



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